

Date: Monday, 5/15/2006 10:42:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOLDING STEP WELDMENT LH
Job Number	: 27086		
Estimate Number	: 10463		
P.O. Number	: N/A	Part Number	: D3388041
This Issue	: 5/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3388 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26652	Drawing Revision	: A
		Material	: N/A
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 5/30/2006
Checked & Approved By	: <i>06.05.15</i>	Qty:	5 Um: Each
Comment	: Est. B 05.06.10 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion 8

Batch: *324563 = 2* *327077 = 3**PE 06.05.24 5*

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388

PE 06.05.24 5

2-Deburr and bevel ends for welding

PE 06.05.24 5

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty

Part Number

Description

Batch

2

D2734

End Cap

*324402**PE 06.05.24 5*

4.0

D33871

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty

Part Number

Description

Batch

2

D3387-1

Arm

325933 = 2 *326670 = 6* *327104 = 2**PE 06.05.29 5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

1606.05.25 4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Touch-up endcap with Alodine → FF 06.06.06
FF 06.05.30

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/23

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FL 06 06 26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

ML 06 06 27 (5)

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty

Part Number

Description

Batch

1

D2808

Spacer

(4) B26648 (6) B7564 SB 06/06/29

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

SB 06/06/29 (5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-25	5-D	weld arms and fwd end cap as per Dwg. D3388 fwd only	JE	06-05-25	4			
06-05-25	5-b	grind end cap flush	FF	06-05-30	5			
06-05-30	5-C	inspection QC 5/9 QC 5/9	PD	06-05-30	5			
				06-05-30	5			
06-05-31	6-b	inspect for foreign objects as per Q51 024	JE	06-05-31	5			
	6-c	weld last end cap as per Dwg. D3388	JE	06-05-31	5			
	6-d	grind end cap flush	FF	06-06-01	5			
		inspection QC 5/9	PD	06-06-02	5			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

do-06-29 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/06/29 (5)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/30 (5)

Job Completion



u 06-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

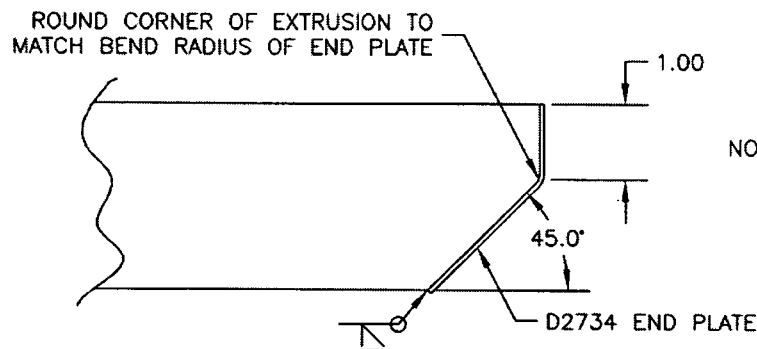
QA: N/C Closed: _____ Date: _____

DART

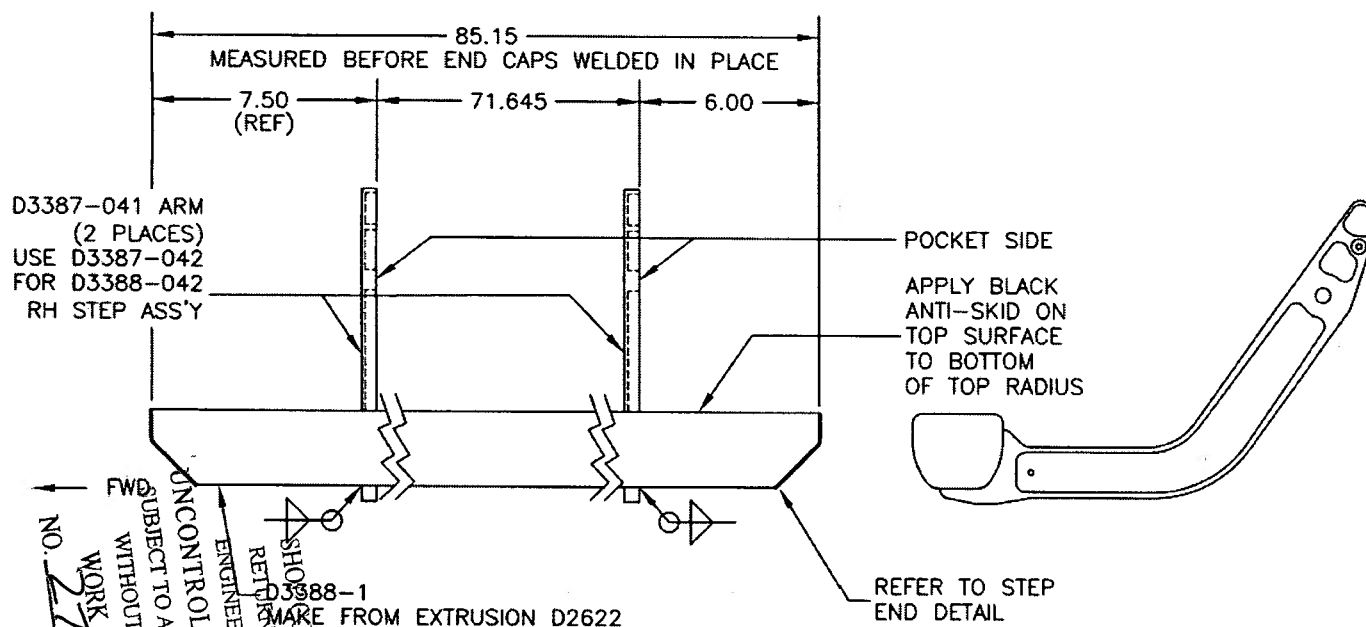
RELEASED

05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3387-041 ARM
(2 PLACES)
USE D3387-042
FOR D3388-042
RH STEP ASS'Y

POCKET SIDE
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

UNCONTROLLED COPY
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27086

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD	
05	05	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
05.01.20	05.01.20	D3388	SHEET 1 OF 1
DATE	TITLE	STEP WELDMENT	SCALE
A	NEW ISSUE		NTS